

20-8682



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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654.7010

Job Sheet 214578



Part No: 654.7010

Job Qty: 18 pcs

Part Name: Girt Strip 4 Hole



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/27/20

Job Tracking No:

Due Date: 11/5/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 654.7000 REV.N/C IPP REV:A 20.10.16 NEW ISSUE FK VERIFY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	18 pcs		11/4/20	0.17	1.80	Waterjet - Flow		on 20/10/27
110	QC 2	18 pcs		11/4/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		on 20/10/27
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
QC 2 - 8									
QC 2 - 66									
QC 2 - 64									
							Plex 10/27/20 10:19 AM Dart.lajeunesse.marie		

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					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
120	NV5000 - 1 - B4B	18 pcs	11/4/20	1.00 18.00	NV5000 - 1 - B4B	
					NV5000 - 2 - B4B	
130	QC 2	18 pcs	11/4/20	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
140	QC 8	18 pcs	11/4/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	

						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
						QC 8 - 66	
						QC 8 - 73	
						QC 8 - 82	
142	Small Fab - 2 - B4B	18 pcs	11/5/20	0.00	1.80	Small Fab - 1 - B4B	
						Small Fab - 2 - B4B	
						Small Fab - 3 - B4B	
						Small Fab - 4 - B4B	
						Small Fab - 5 - B4B	
						Small Fab - 6 - B4B	
						Small Fab - 7 - B4B	
						Small Fab - 8 - B4B	
						Small Fab - 9 - B4B	
						Small Fab - Various 1 - B4B	
						Small Fab - SCH-B	
144	QC 5	18 pcs	11/5/20	0.00	0.00	QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
						QC 5 - 82	
						QC 5 - SCH-B	
150	Packaging 3-1 - Stock - B4B	18 pcs	11/5/20	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	

				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
160 QC 21 - SA	18 pcs	11/5/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 9	
				QC 21 - SA - 77	
				QC 21 - SA - 28	
Part Op 100 - 1-Cut as per DWG. DWG. Rev: <u>N/C</u> PROG. Rev: <u>N/C</u> 2-Deburr if necessary Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - 1-Machine as per folio FD406 FOLIO REV: _____ DWG REV: _____ 2-Deburr 130 - QC2- Inspect parts off machine FAI/FAIB 140 - QC8- Inspect parts - second check 142 - -Score surface, before applying primer, using 40 GRIT sand paper. 150 - Identify as per dwg & Stock Location: _____ 160 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M301S11GA-H50	301 SS Sheet - 1/2 hard 0.125	.9720 sf (.054 ea)	100-Waterjet - Flow - 1	<u>8302478</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M301S11GA-H50	1	28	0	
Part Specifications					
Specifications could not be found.					

Plex 10/27/20 10:19 AM Dart.lajeunesse.marie



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Container No: S308858



Part: 654.7010

Job No: 214578

Serial No/Batch: S308858

Revision: REV.N/C

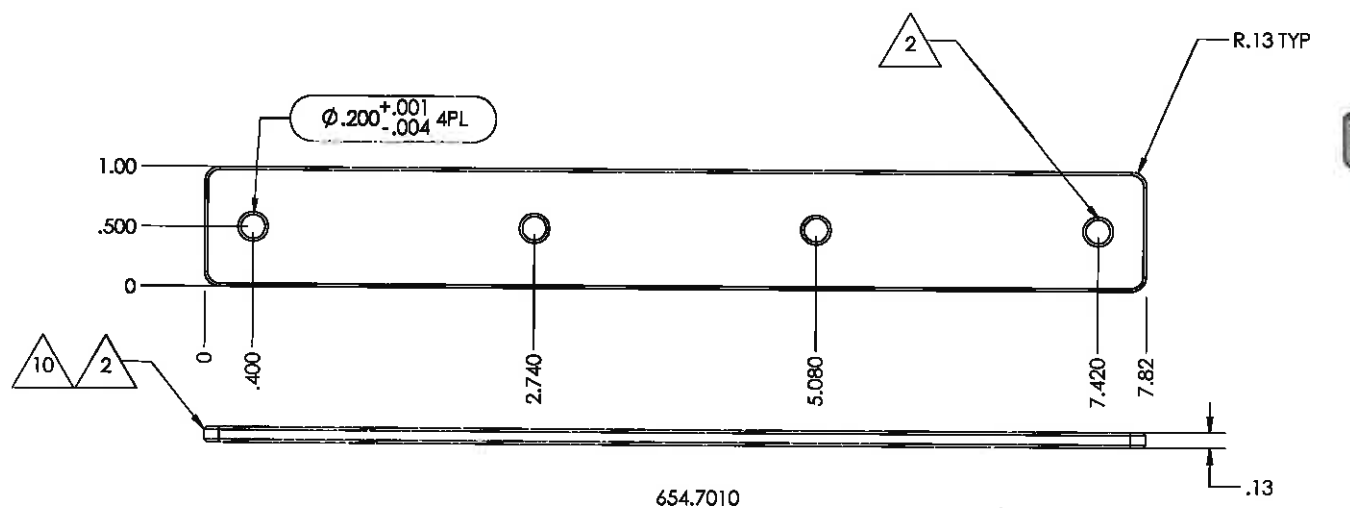
Inspector:

Exp Date:

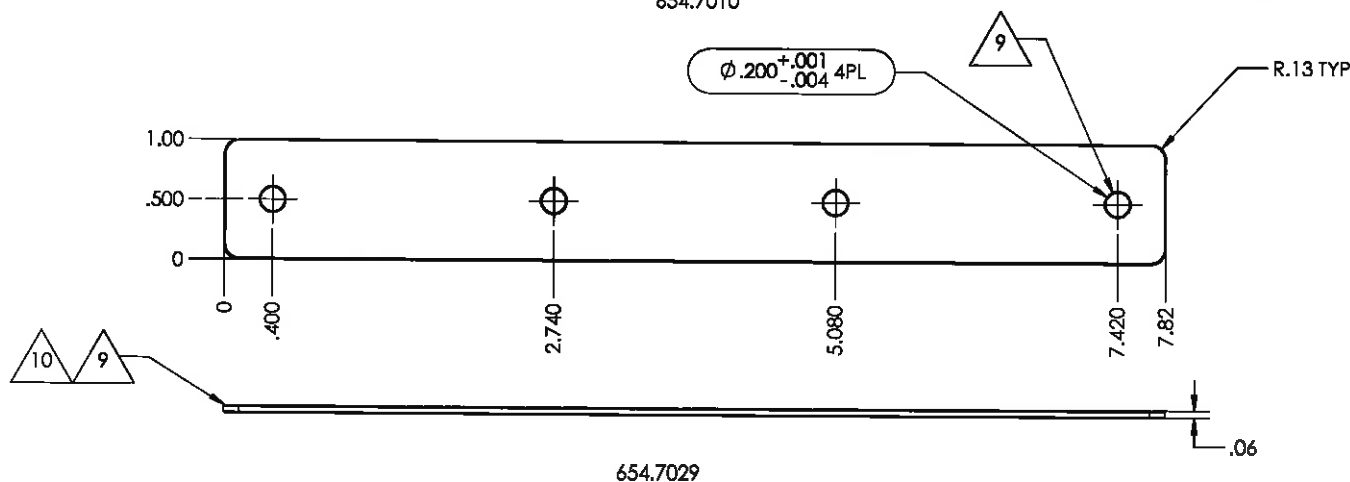
Instructions:

Date: 10/27/20

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654.7010



654.7029

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 2145+8 MWS

2010-27

DRAWN: DRS		DATE: 10/14/04	
CHECKED: J. BROWN		DATE: 10/14/04	
DESIGNED: J. BROWN		DATE: 10/14/04	
MATERIAL: 6061-T6		FINISH: ANODIZE	
QUANTITY: 100		UNIT: INCHES	
PART NAME: GIRT BARS AND DOUBLERS		PART NO: 654.7000	
SCALE: NONE		SHEET: 2 OF 10	

Entered: 2R Date: NOV 25 2020



NCR No. 20-8682

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>214578</u> Part No. <u>6547010</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☒ Supplier ☐ Quality ☐			
Date : <u>20-10-27</u>	Sequence #: <u>100</u>	QTY Affected : <u>13</u>		MRB (QSI042) DAS 9 9-89 <u>20-11-13</u>	
Description Work Order Deviation <u>holes are all tapered (.192"-.210")</u>		Disposition <u>Scrap destroy. High tolerance on holes</u> <u>- Ports will now be cut using</u> <u>OMax to prevent tapered</u>		Completed By <u>MHC 20/11/13</u> Lead hand / Supervisor DAS 9 9-89 <u>20-11-13</u> QC / QA Coordinator DAS 9 9-89 <u>20-11-13</u>	
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					